

~~Ship~~ Ship Friday

Work Order ID 69376

Tuesday, May 10, 2011 1:26:49 PM



Page 1

Item ID: D3948-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Anchor

Start Date: 5/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

H

Date: 11-05-10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3948

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304 . 063

1-Cut as per Dwg D3948-3

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

RB11-5-10

OS

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

RB11-5-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

5/10/11

Counted
X25

Memo

130



Small Fab

Small Fab

Memo

COUNTERSINK AS PER DWG

0.00

0.00

5/11/11 (25)

140



Brake NC

Brake NC

Memo

Bend as per Dwg

0.00

0.00

5/11/12

25

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/15/12

count
(x25)

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

MA S

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 69376

Tuesday, May 10, 2011 1:26:49 PM



Page 4

Item ID: D3948-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Anchor

Start Date: 5/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EBU/05/12 (25)

190

0.00



Small Fab

Memo

0.00

Small Fab

INSTALL NUT PLATES AS PER DWG

EBU/05/12 (25)

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

EBU/05/12

counted

(+25)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 69376

Tuesday, May 10, 2011 1:26:49 PM



Page 5

Item ID: D3948-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate, Anchor

Start Date: 5/10/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: 95

0.00



Packaging

Memo

0.00

Packaging

11/5/12 250

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/12 250UHF
11-05-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 10, 2011 1:26:56 PM

Page 1
T

Work Order ID: 69376



Parent Item: D3948-043



Parent Item Name: Plate, Anchor

Start Date: 5/10/2011

Required Date: 5/11/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

202.9000

0.0218

0.183579

1



304/316 Sheet .063

RB 11-5-10

Location

Loc Qty

Loc Code

MAT020

202.9

117275

42.9

117653

160

117275

28

MS21059L3

Purchased

No

180

Each

134.0000

1

8



Nut Plate

8/54/05/25

Location

Loc Qty

Loc Code

ST301

128

117423

28

117505

100

ST302

6

116706

6

25

MS20426AD3-3

Purchased

No

180

Each

2,755.000

2

16



Rivet

8/54/05/25

Location

Loc Qty

Loc Code

ST316

2755

19099

2755

50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>09376</i>
Description: Plate		Part Number:	D3948-3
Inspection Dwg: D3948	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	<i>.100</i>	<i>✓</i>		<i>V 1302</i>	
Ø0.250	+0.005/-0.001	<i>.251</i>	<i>x</i>		<i>V</i>	
0.688	+/-0.010	<i>.689</i>	<i>✓</i>		<i>V</i>	
1.254	+/-0.010	<i>1.258</i>	<i>✓</i>		<i>V</i>	
0.344	+/-0.010	<i>.344</i>	<i>✓</i>		<i>V</i>	
1.25	+/-0.030	<i>1.257</i>	<i>✓</i>		<i>V</i>	
2.51	+/-0.030	<i>2.518</i>	<i>✓</i>		<i>V</i>	
0.63	+/-0.030	<i>.632</i>	<i>✓</i>		<i>V</i>	
0.063	+/-0.010	<i>.061</i>	<i>✓</i>		<i>V</i>	

Measured by:	<i>B</i>	Audited by:	<i>S</i>	Prototype Approval:	N/A
Date:	<i>11-5-10</i>	Date:	<i>11/05/11</i>	Date:	N/A
Rev	Date	Change	Revised by	Approved	
A	09.07.29	New Issue P/O D3948-043	KJ <i>[Signature]</i>	<i>[Signature]</i>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

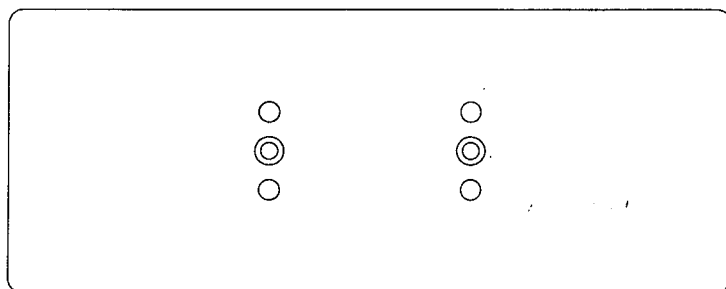
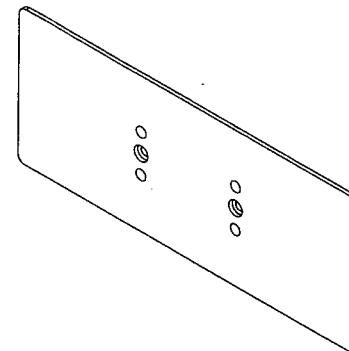
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3948-041	PLATE, ANCHOR
2	1	D3948-1	PLATE
3	2	MS21059L3	NUTPLATE (OR MS21059-3)
4	4	MS20426AD3-3	RIVET

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 09374
PL11-05-10



D3948-1

D3948-041 PLATE, ANCHOR

RELEASED
09/06/08

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs

B	-3F NOW MADE FROM 304 SS (ZN A8-5), 0.063 THICK WAS 0.040 (ZN A8-3, A8-5), -.043/-3/-3F WIDER (ZN B6-4, B6-5)	CP	09.06.08
A	NEW ISSUE	CP	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	921	DART AEROSPACE LTD	
DRAWN	921	HAWKESBURY, ONTARIO, CANADA	
CHECKED	21	DRAWING NO.	REV. B
MFG APPR.	21	D3948	SHEET 1 OF 5
APPROVED	21	TITLE	SCALE
DE APPR.	21	PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL - NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

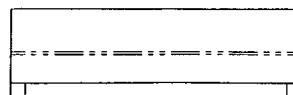
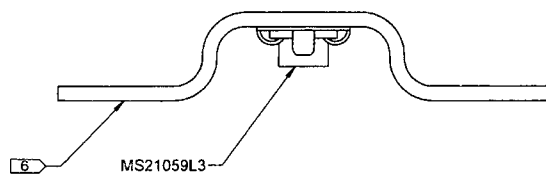
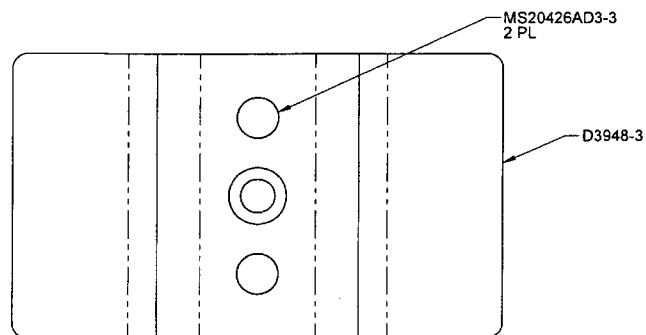
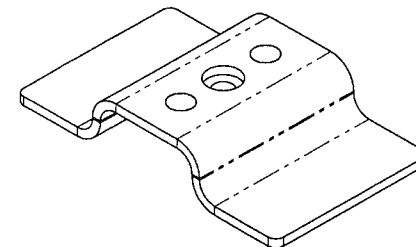
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-043	PLATE, ANCHOR
2	1	D3948-3	PLATE
3	1	MS21059L3	NUTPLATE (OR MS21059-3)
4	2	MS20426AD3-3	RIVET

**D3948-043 PLATE, ANCHOR**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

DESIGN	92	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	92			
CHECKED	92		DRAWING NO.	REV. B
MFG APPR.	92		D3948	SHEET 2 OF 5
APPROVED	92		TITLE	SCALE
DE APPR.	92		PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD		
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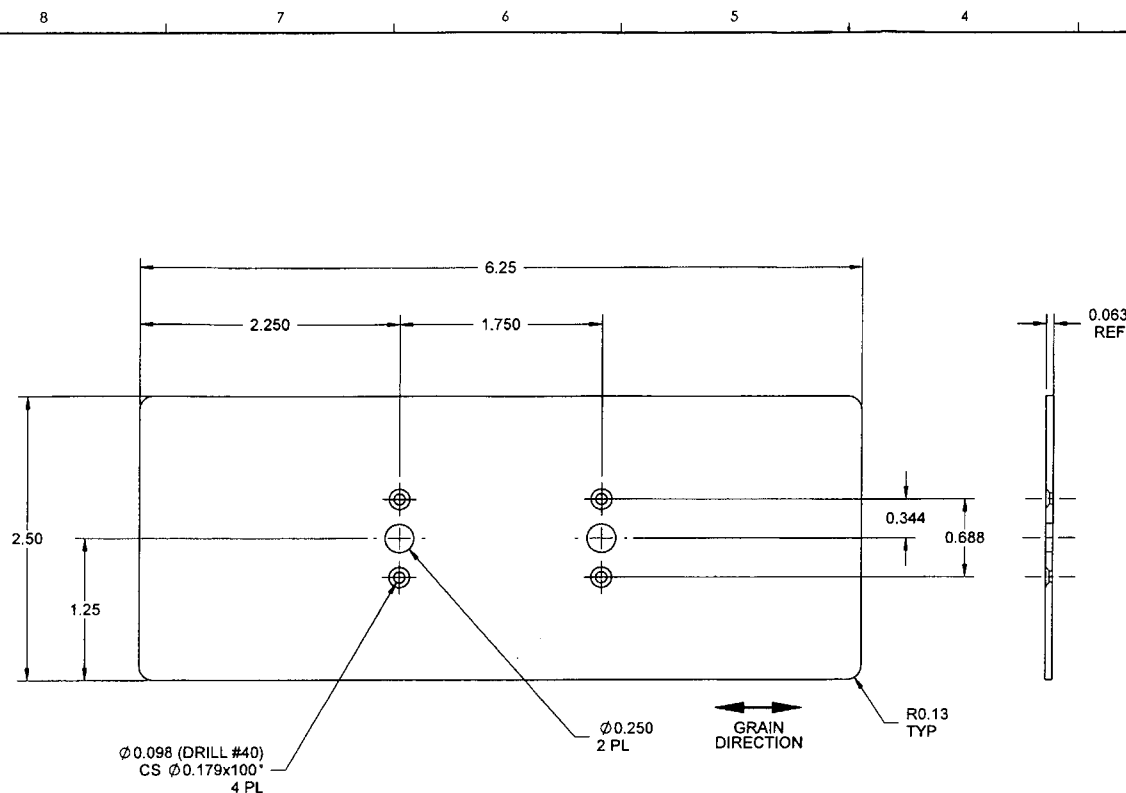
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3948-1 PLATE

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063" THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.10 lbs

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	97	D3948	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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RELEASED
09/06/08

u/b 69376

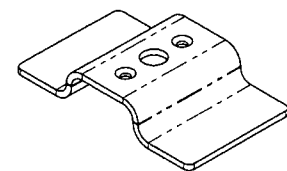
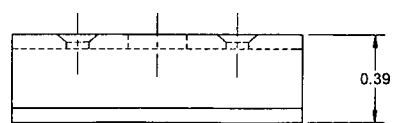
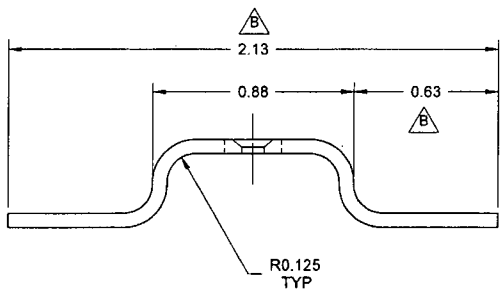
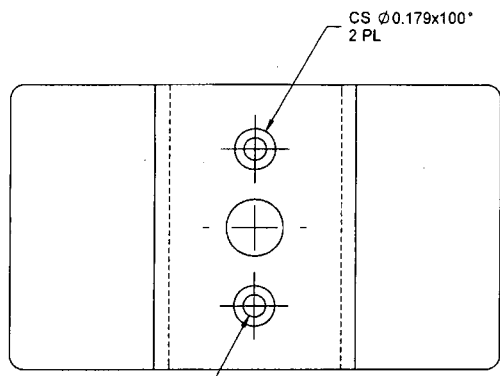
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



u/o 6A374

D3948-3 PLATE

RELEASED
8/16/16

- NOTES:
- 1) MATERIAL: MAKE FROM D3948-3F
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	97	D3948	SHEET 4 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	PLATE, ANCHOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

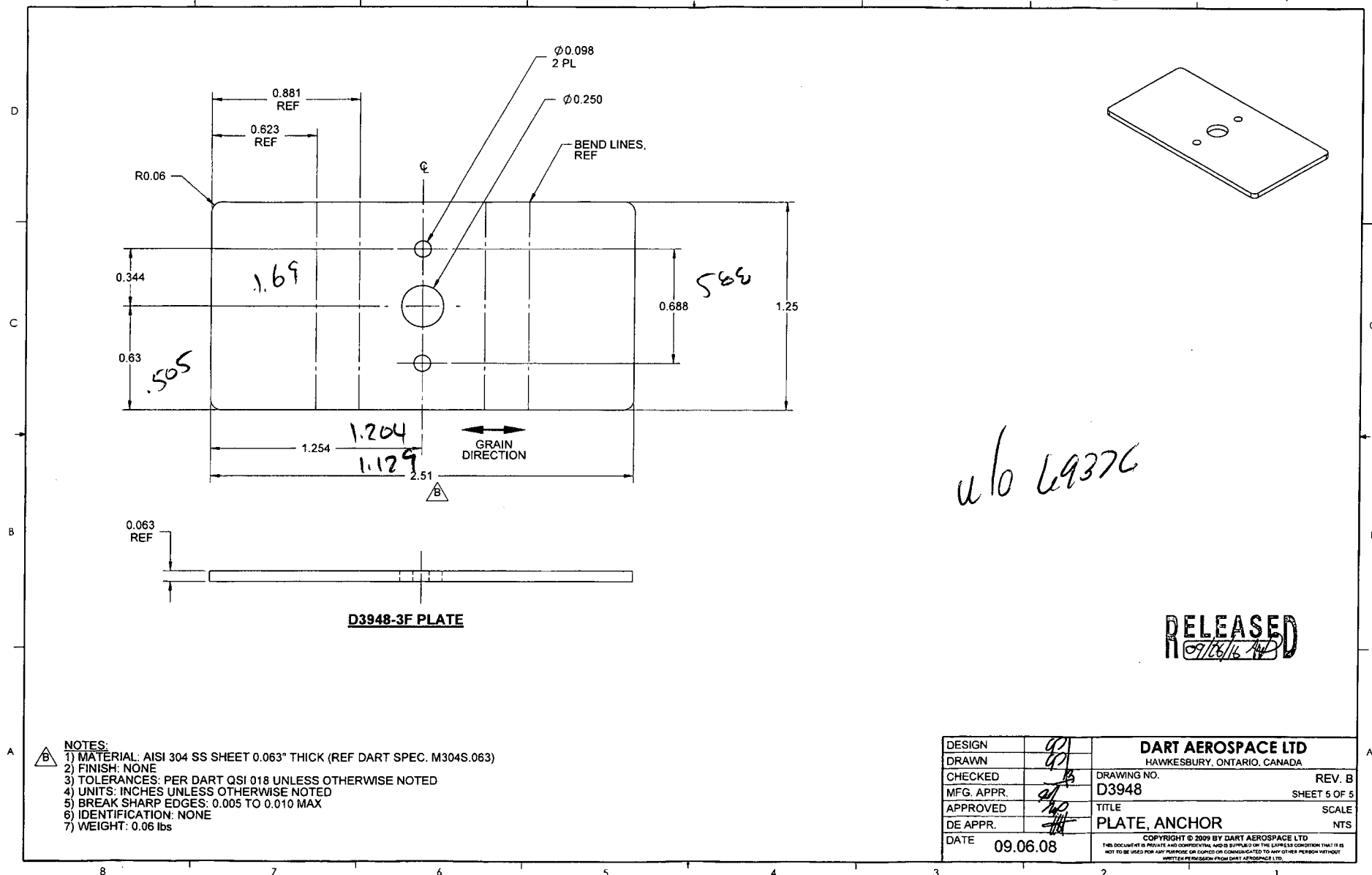
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



D3948-3F PLATE

RELEASED
09/16/16

- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET 0.063" THICK (REF DART SPEC. M304S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

DESIGN	931	DART AEROSPACE LTD	
DRAWN	931	HAWKESBURY, ONTARIO, CANADA	
CHECKED	931	DRAWING NO.	REV. B
MFG. APPR.	931	D3948	SHEET 5 OF 5
APPROVED	931	TITLE	SCALE
DE APPR.	931	PLATE, ANCHOR	NTS
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8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
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